

Date: Thursday, 8/23/2007 11:53:01 AM
User: Kim Johnston

Process Sheet

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	ACCESS PANEL ASSEMBLY
Job Number	:	34240			
Estimate Number	:	12948			
P.O. Number	:	N/A	Part Number	:	D3259041
This Issue	:	8/23/2007	Drawing Number	:	D3249 REV A1
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A	Drawing Revision	:	A1
Previous Run	:	33655	Material	:	N/A
		Type : SMALL /MED FAB	Due Date	:	9/3/2007
Written By	:	<u>[Signature]</u>	Qty:		307
Checked & Approved By	:	<u>[Signature]</u>	Um:		Each
Comment	:	Est Rev:A New Issue 07-07-19 JLM Verified By:EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick Assembly Kit

2.0 D32591 panel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
panel
Batch: B34736

3.0	D32593	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Doubler:
 Batch: B23265 1x 334

4.0	D32595	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Spacer
Batch: B3y 737

50 D32597 Door



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Door
Batch: 1334738

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34240

Part Number: D3259041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D31615

Hinge 9.9"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 9.9"

Batch: 34735

CU

7.0

D32601

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spring

Batch: B34205

CU

8.0

127H5

HALF GROMMET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

HALF GROMMET

Batch: M105518

CU

9.0

250018C3Y

RIGHT RECEPTACLE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIGHT RECEPTACLE

Batch: M100034

SO

10.0

2501W20020C3Y

STUD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

STUD

Batch: M100398

SP

11.0

MS20426AD44

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch: M10021

SP

12.0

MS20470AD34

Rivet, Universal Head



Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s)

Rivet, Universal Head

Batch: M15541

7-11-15 SO

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 08/11/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 8/23/2007 11:53:01 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 34240

Part Number: D3259041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Batch: M9682

SL

7-11-15 3x

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259 .

Note: Keep .040" Gap all around door.

mlo7/11/16

(x3)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JA 11-16 (3)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 182

AS 07/11/16

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

209/11/19

Job Completion



U 27-11-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

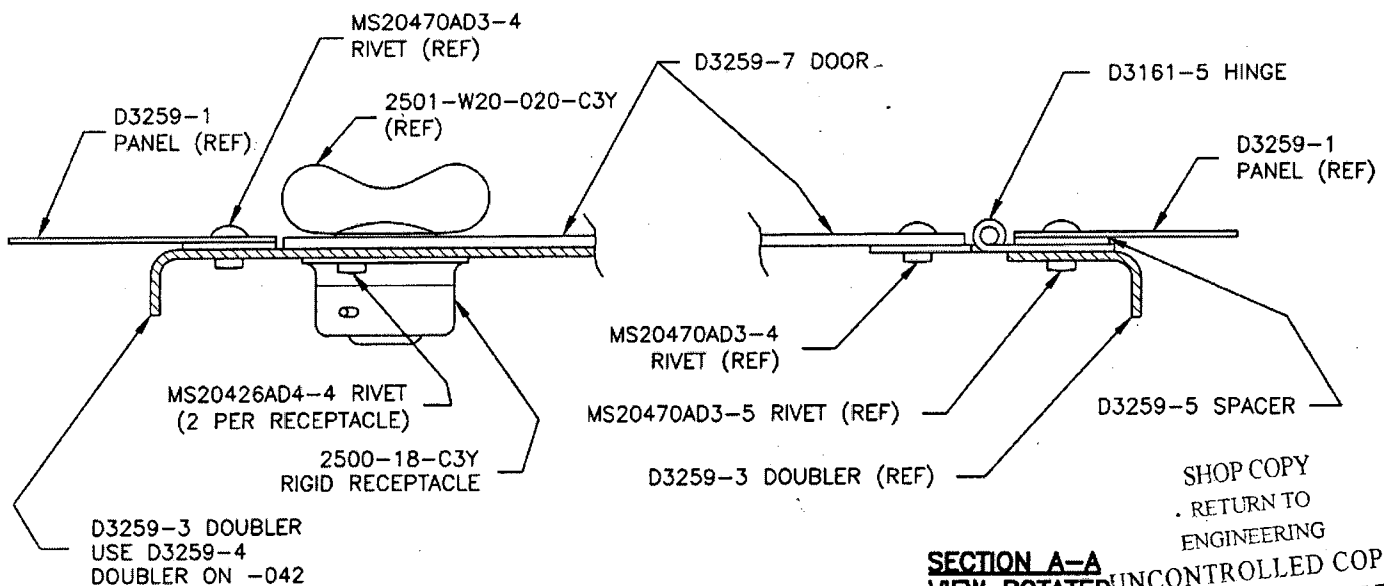
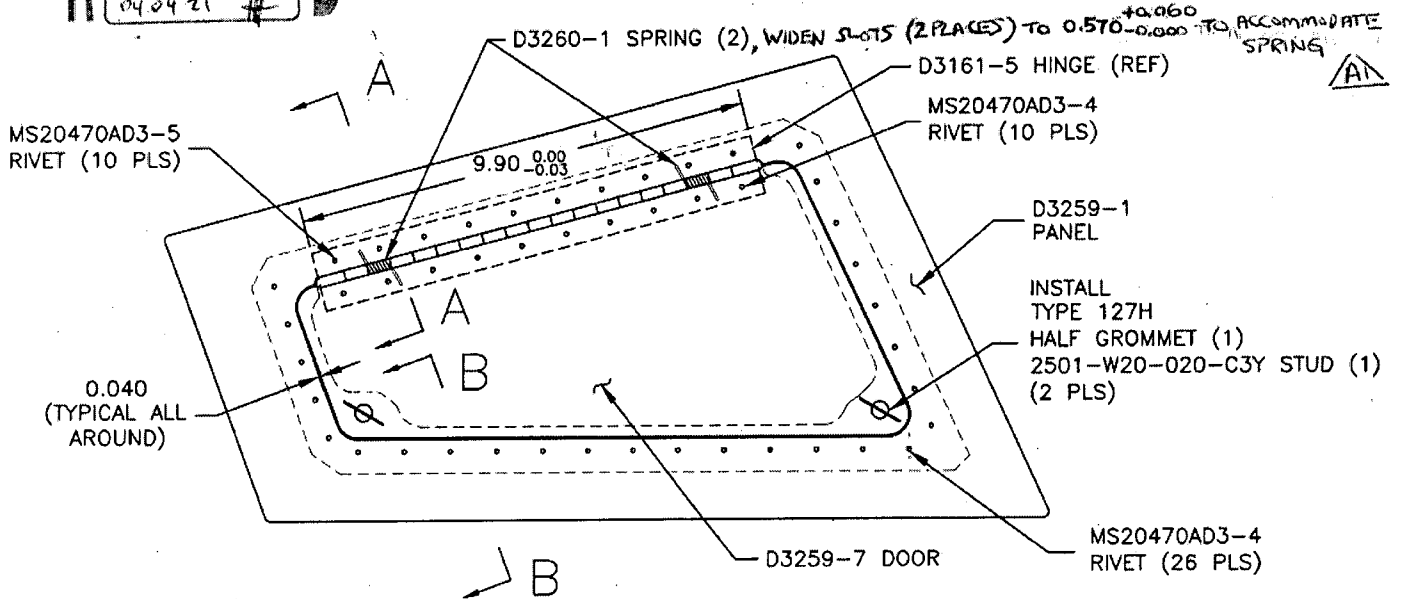
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	RF	DRAWN BY	UP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO. D3259
				REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY	SCALE 1:4
A	04.02.25	NEW ISSUE		
AI	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING		

RELEASED
040421 #



SECTION B-B
VIEW ROTATED

SECTION A-A
VIEW ROTATED

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NO. 34240

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

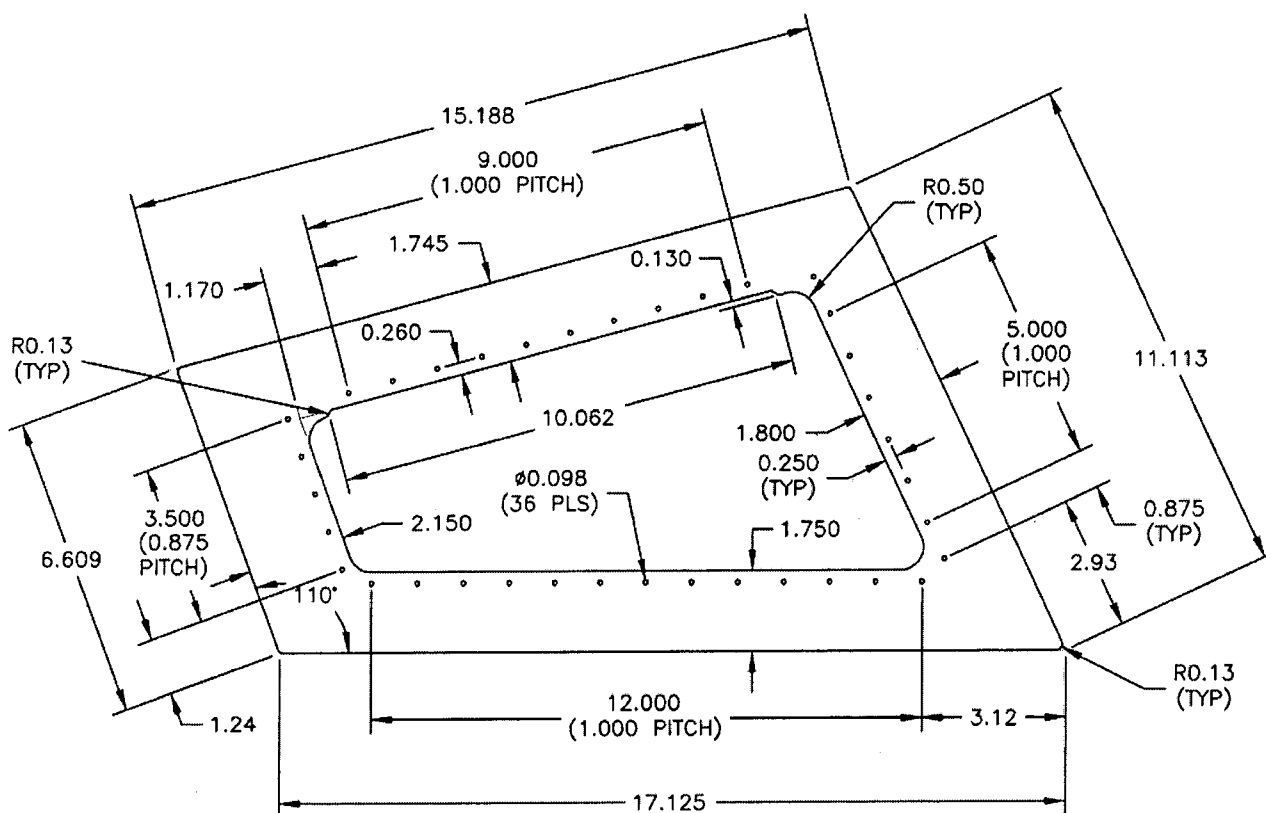
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.05



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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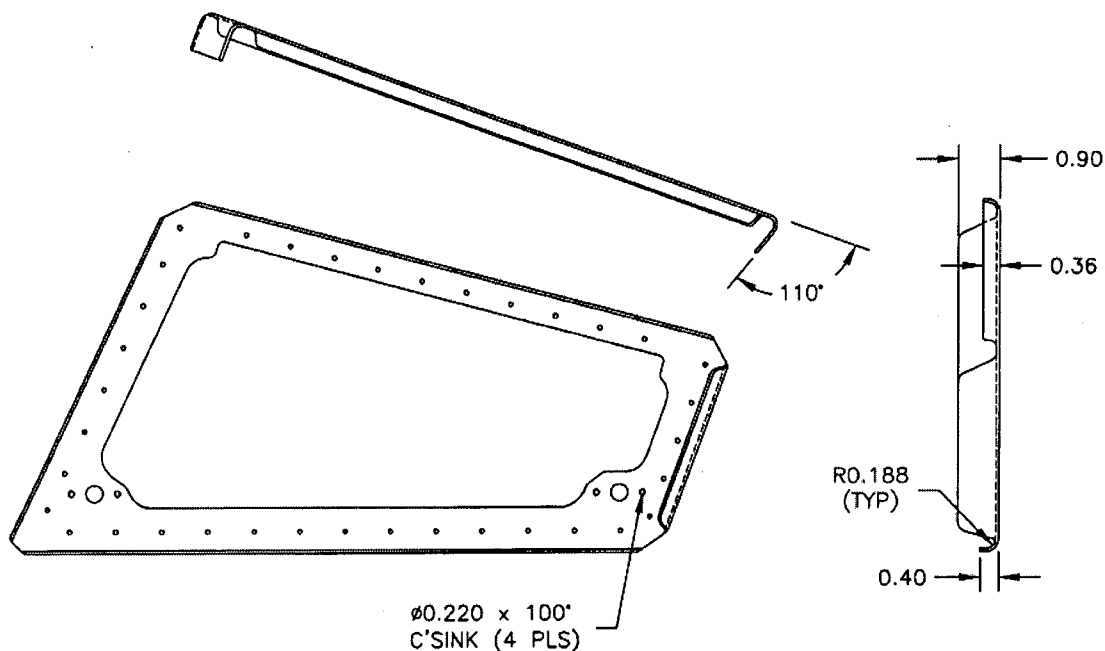
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.14 [Signature]



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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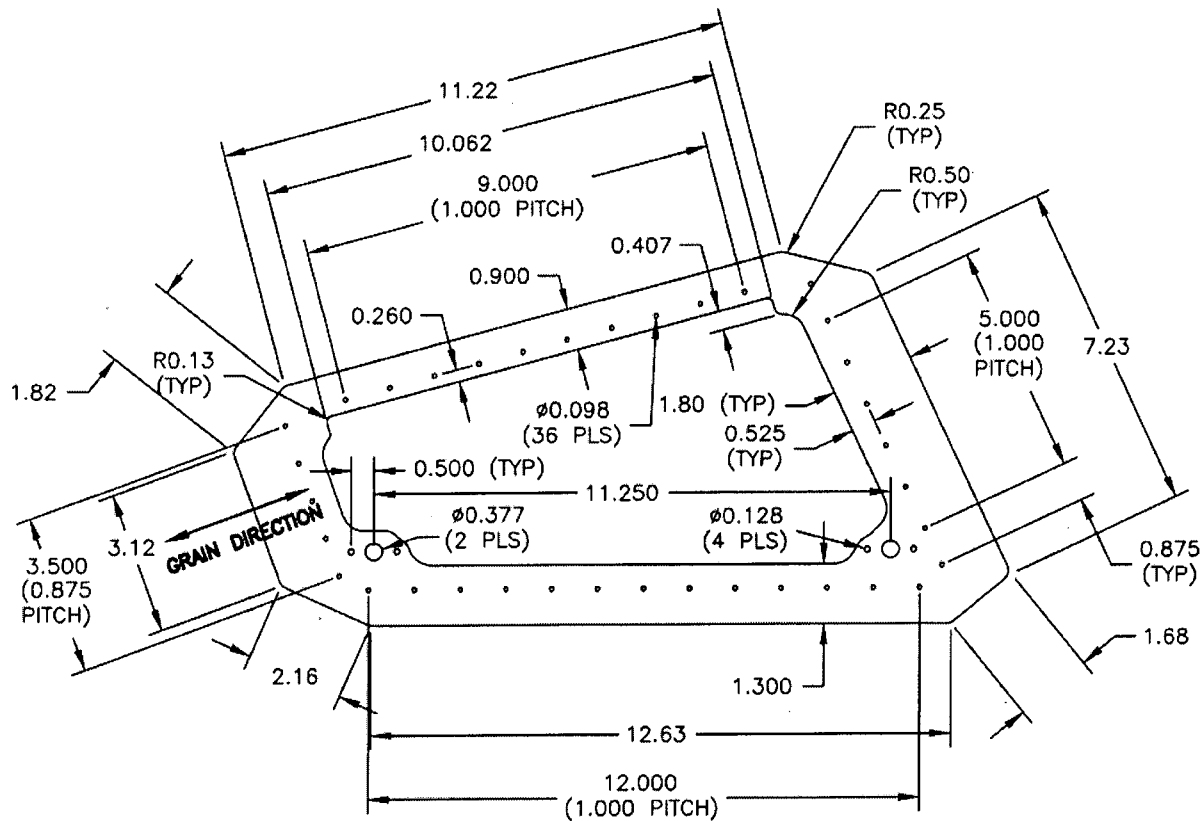
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.14 *[Signature]*



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

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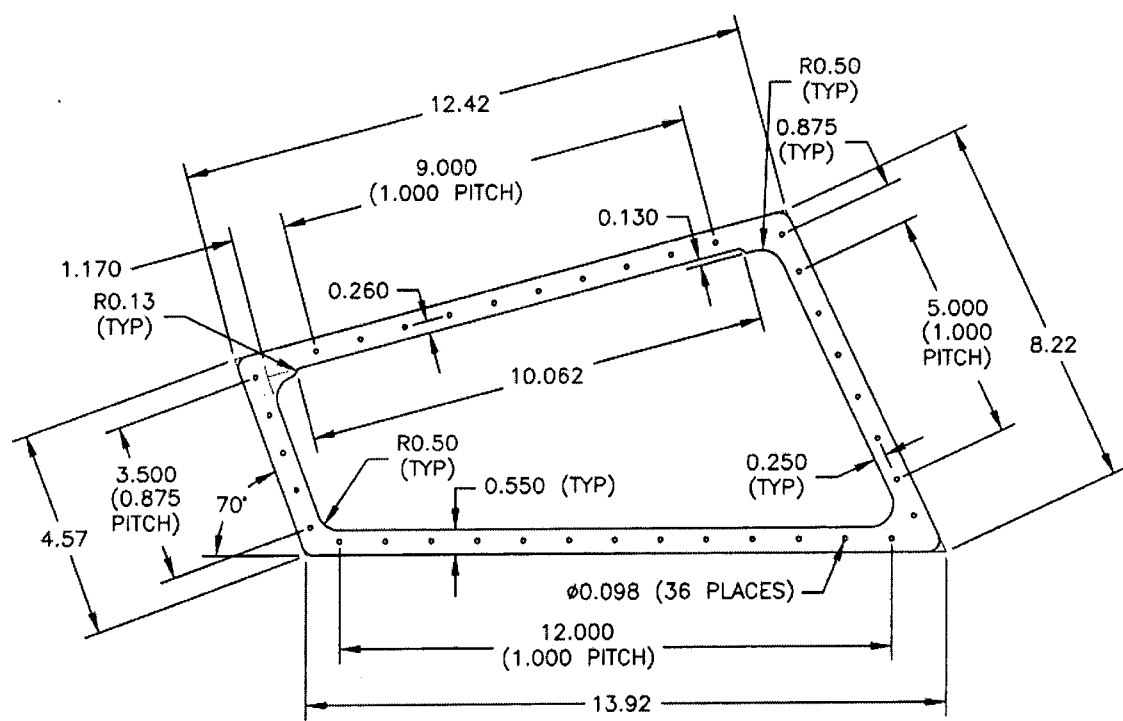
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

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04.04.05 [Signature]



D3259-5 SPACER

(Ø0.098 HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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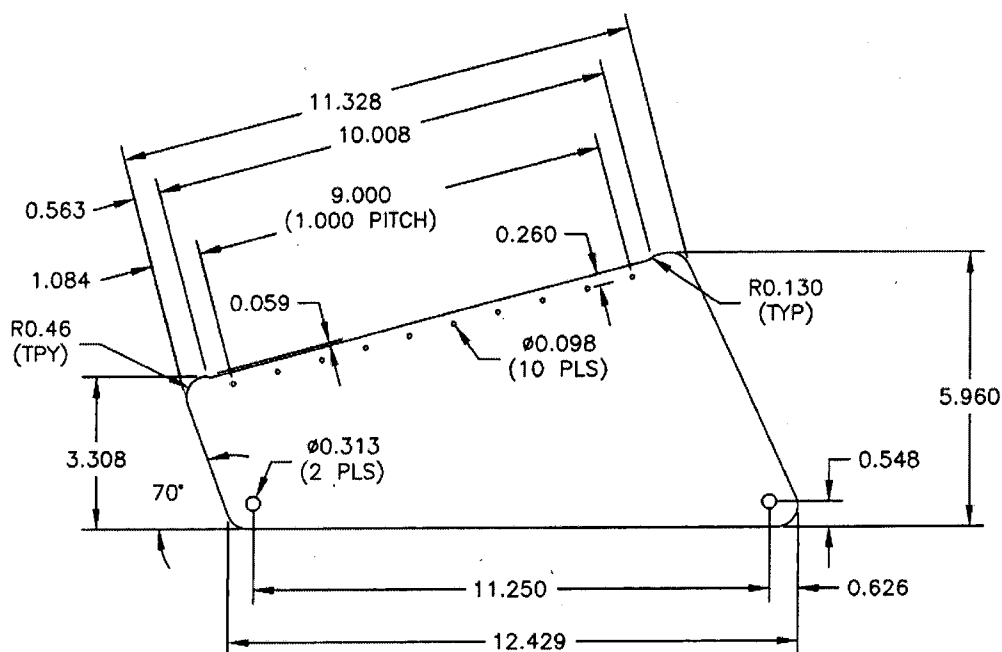
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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